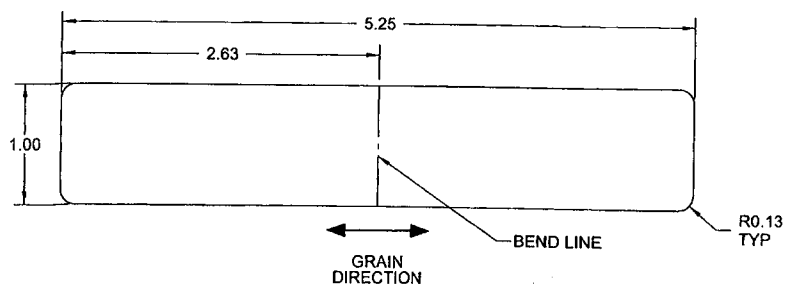
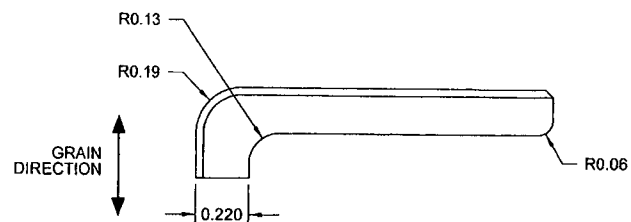


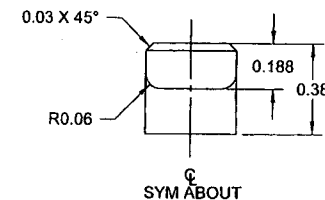
**D3572-5 BRACKET**  
(MAKE FROM D3572-5F)



**D3572-5F FLAT PATTERN**



**D3572-3 GUIDE**



wlo 59305

**RELEASED**  
9/4/13

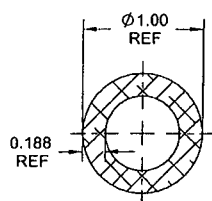
**D3572-3 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
AMS-QQ-A-200/8 (OR AMS4160)  
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

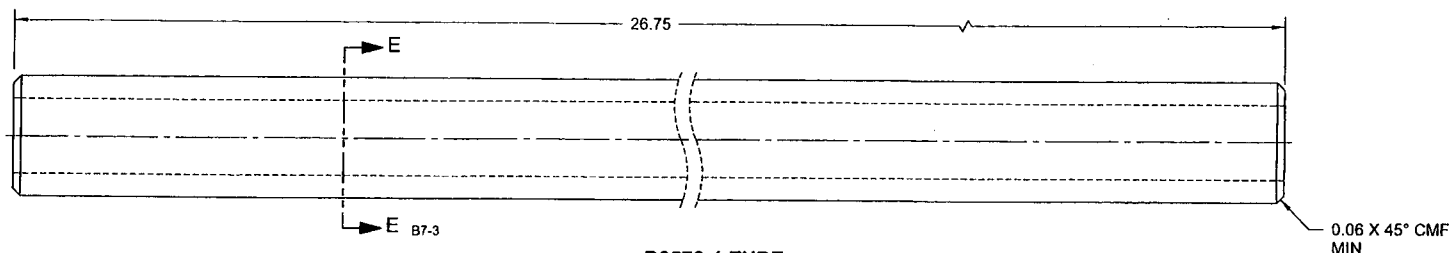
**D3572-5 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3572	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GUIDE ASSEMBLY	NTS
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**SECTION E-E C5-3**



**D3572-1 TUBE**

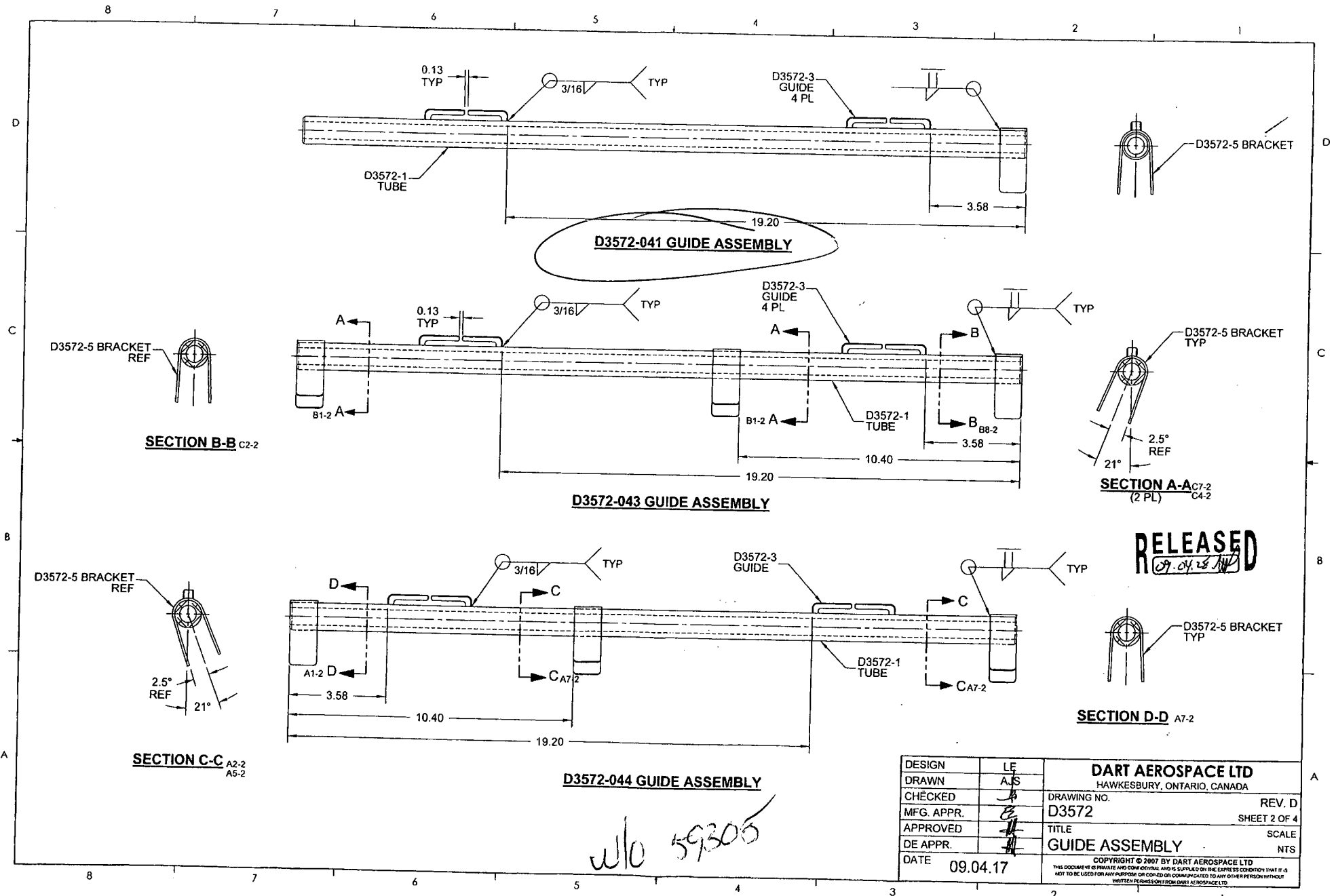
**D3572-1 NOTES:**

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL  
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8  
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

*WU 59305*

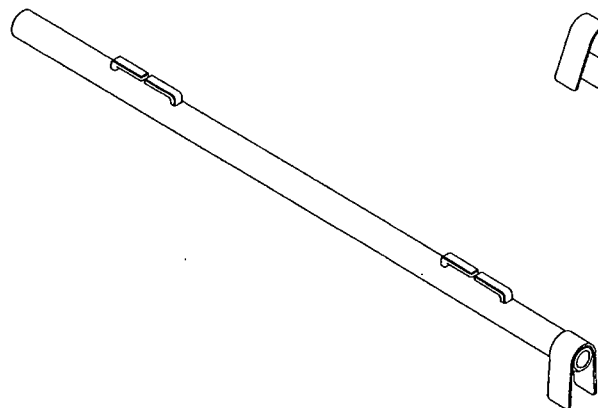
**RELEASED**  
*09/04/17 MP*

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MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 4	
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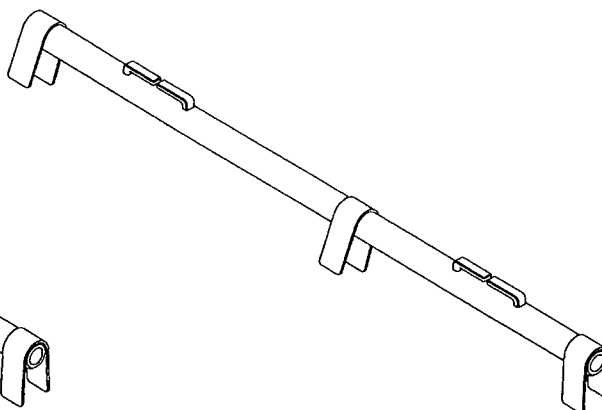


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MFG. APPR.	<i>[Signature]</i>	D3572	SHEET 2 OF 4
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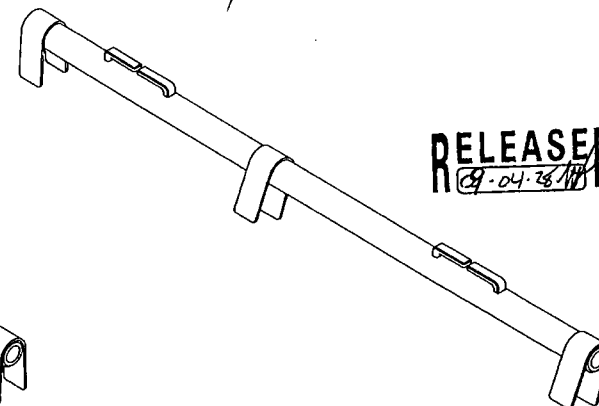
ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C



**D3572-041 GUIDE ASSEMBLY**



**D3572-043 GUIDE ASSEMBLY (UH-1)**



**D3572-044 GUIDE ASSEMBLY (UH-1)**

SE  
E  
EM  
UNCONTROL  
SUBJECT TO A  
WITHIN THE  
WORK ORDER  
NO. 39305  
p10-5-3

**RELEASED**  
09-04-28/10

**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs  
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO.	REV. D
MFG. APPR.	LE	D3572	SHEET 1 OF 4
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# Picklist Print

Monday, May 31, 2010 1:02:55 PM

Page 1

Work Order ID: 59305

Parent Item: D3572-041

Parent Item Name: Guide Assembly

Start Date: 5/31/2010

Required Date: 6/7/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-07 JLM  
IPP rev B revB dwg EC  
IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM  
IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

M6061T6T1.000W.188 Purchased No 110 f 98.1240 2.34 24.63158



6061T6 RD TUBE 1.00 X .188W

Location	Loc Qty	Loc Code
MAT	24.375	
114520	24.375	
MAT016	73.749	
113511	26.916	
114089	46.833	

FL 10-6-3

11.4

11.4

D3572-3 Manufactured No



Guide

D3572-5



Bracket

5x59640

B59142 X 35

Manufactured No

130 Each 0.0000 4 40



10-9-30  
FL 10-6-3

130 Each 18.0000 1 10



Q 10-6-3

Location	Loc Qty	Loc Code
WA	18	
54119	18	

59405

9

1 10-5-30

**Work Order ID 59305**

Monday, May 31, 2010 1:02:50 PM

Page 4



Item ID: D3572-041

Accept



Setup Start



Revision ID:

Item Name: Guide Assembly

Stop



Start Date: 5/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
	Packaging								
Packaging	Memo 260	0.00							
220	QC21- Final Inspection - Work Order Release	0.00							
	QC								
Quality Control	Memo	0.00							

*Handwritten signature: C. 10/19/18*

*Handwritten signature: 10/10/19*  
*Handwritten signature: MF*  
*Handwritten text: 10-10-18*

# Work Order ID 59305

Monday, May 31, 2010 1:02:50 PM



Page 3

Item ID: D3572-041

Accept



Setup Start



Revision ID:

Item Name: Guide Assembly

Stop



Start Date: 5/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

Chemical Conversion Coat per QSI005 4.1

0.00

=) M 10/10/18

2

4

HandFinish

Memo

0.00

Hand Finishing

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

BR 10-10-18

2

Powdercoat

M 11/25/88

Memo

0.00

Powder Coating

START TIME: 2:45  
OVEN TEMPERATURE: 320  
FINISH TIME: 3:15

200

QC3- Inspect Part Finish

0.00

C 10/14/18 2

QC

Memo

0.00

Quality Control

**Work Order ID 59305**

Monday, May 31, 2010 1:02:50 PM



Page 2

Item ID: D3572-041

Accept



Setup Start



Revision ID:

Item Name: Guide Assembly

Stop



Start Date: 5/31/2010 Start Qty: 10.00

Required Date: 6/7/2010 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: M111385 0.00  
Large Fab

Memo

0.00

1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572  
2- grind weld flush at the end of tube onlyPl 10.10.15AL 10-9-30

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

210/10/15

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

2 PD 10.10.15



# Work Order ID 59305 -2

Monday, May 31, 2010 1:02:49 PM



Page 1

Item ID: D3572-041

Accept



Setup Start



Revision ID:

Item Name: Guide Assembly

Stop



Start Date: 5/31/2010 Start Qty: ~~10:00~~ 2

Required Date: 6/7/2010 Req'd Qty: 10:00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: H

Date: 10-5-31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3572	Rev D								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Cut Tube D3572-1 as per Dwg D3572 2-deburr both ends								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

H 10-10-19  
10-6-3

H 10-6-3 X10

S 10/06/03

X10